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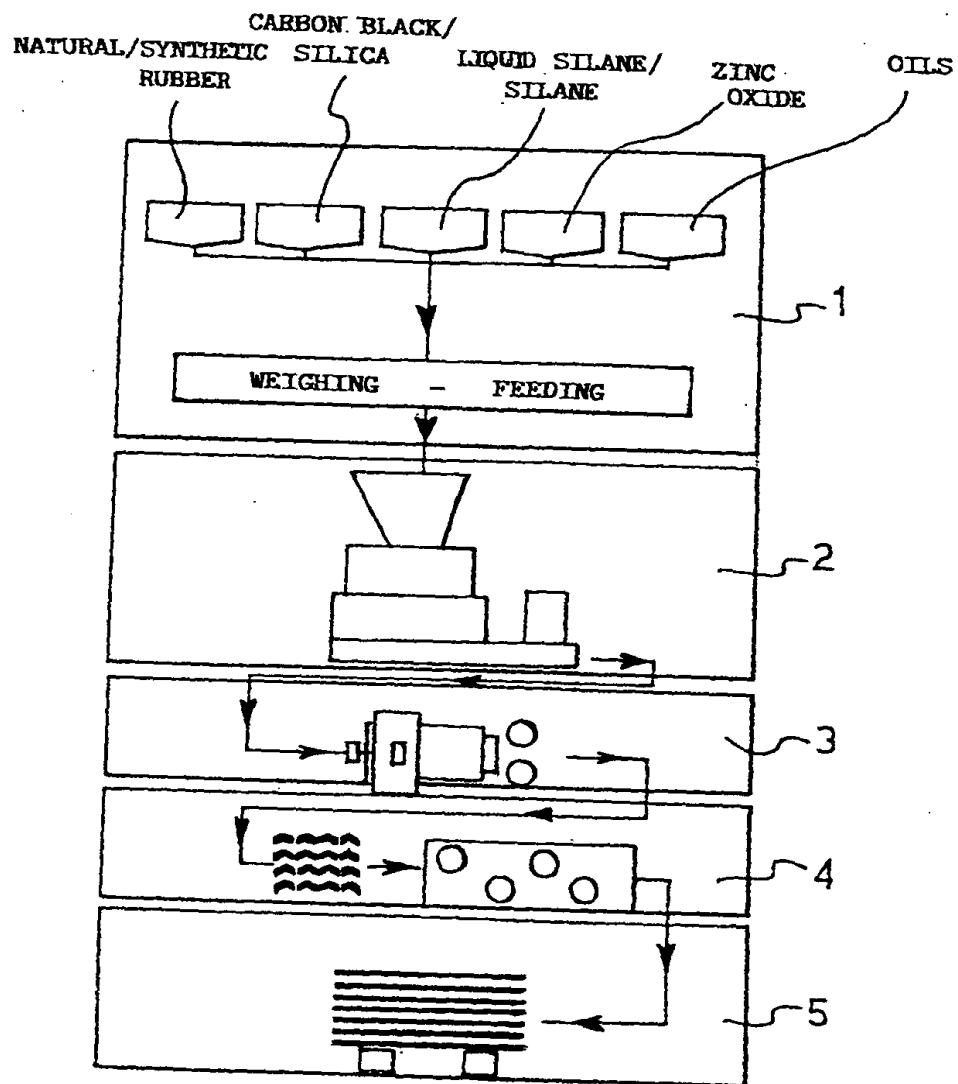


FIG. 1

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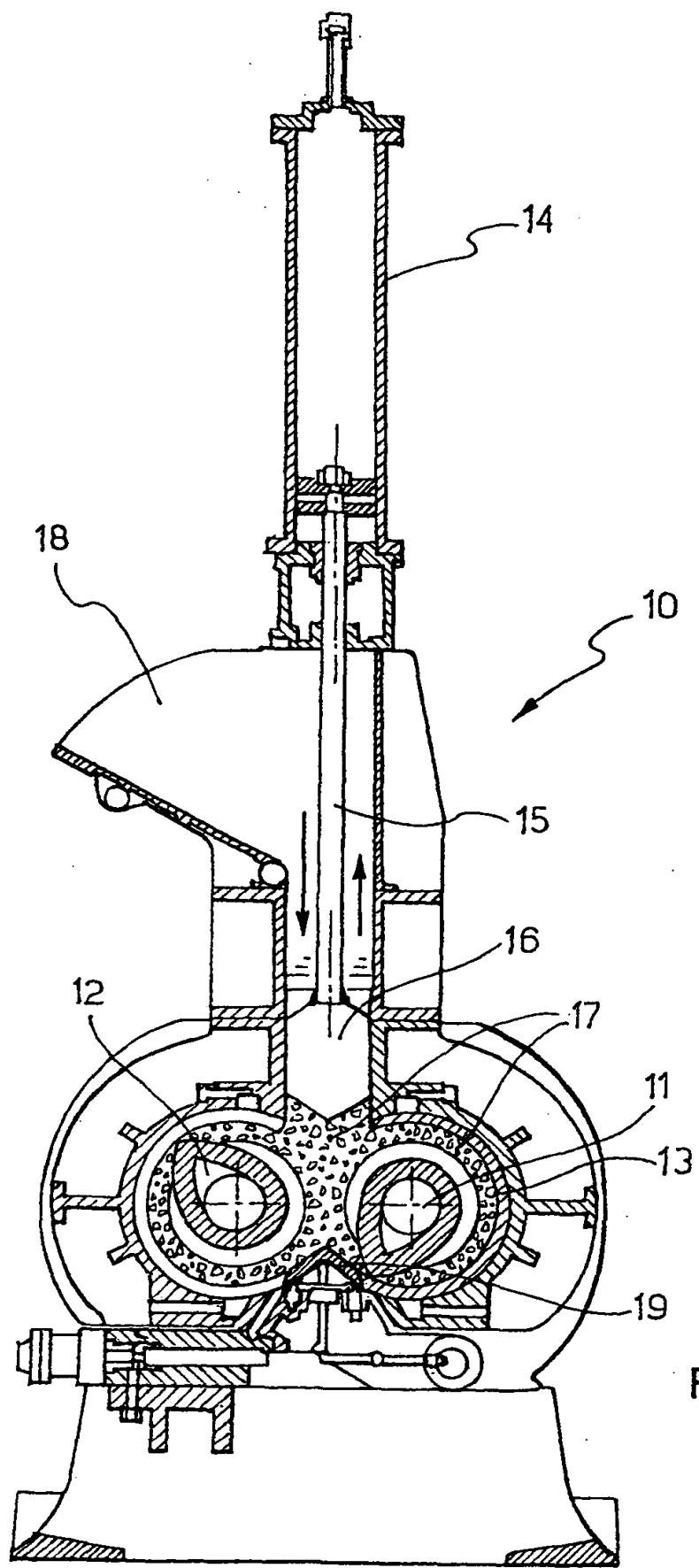


FIG. 2

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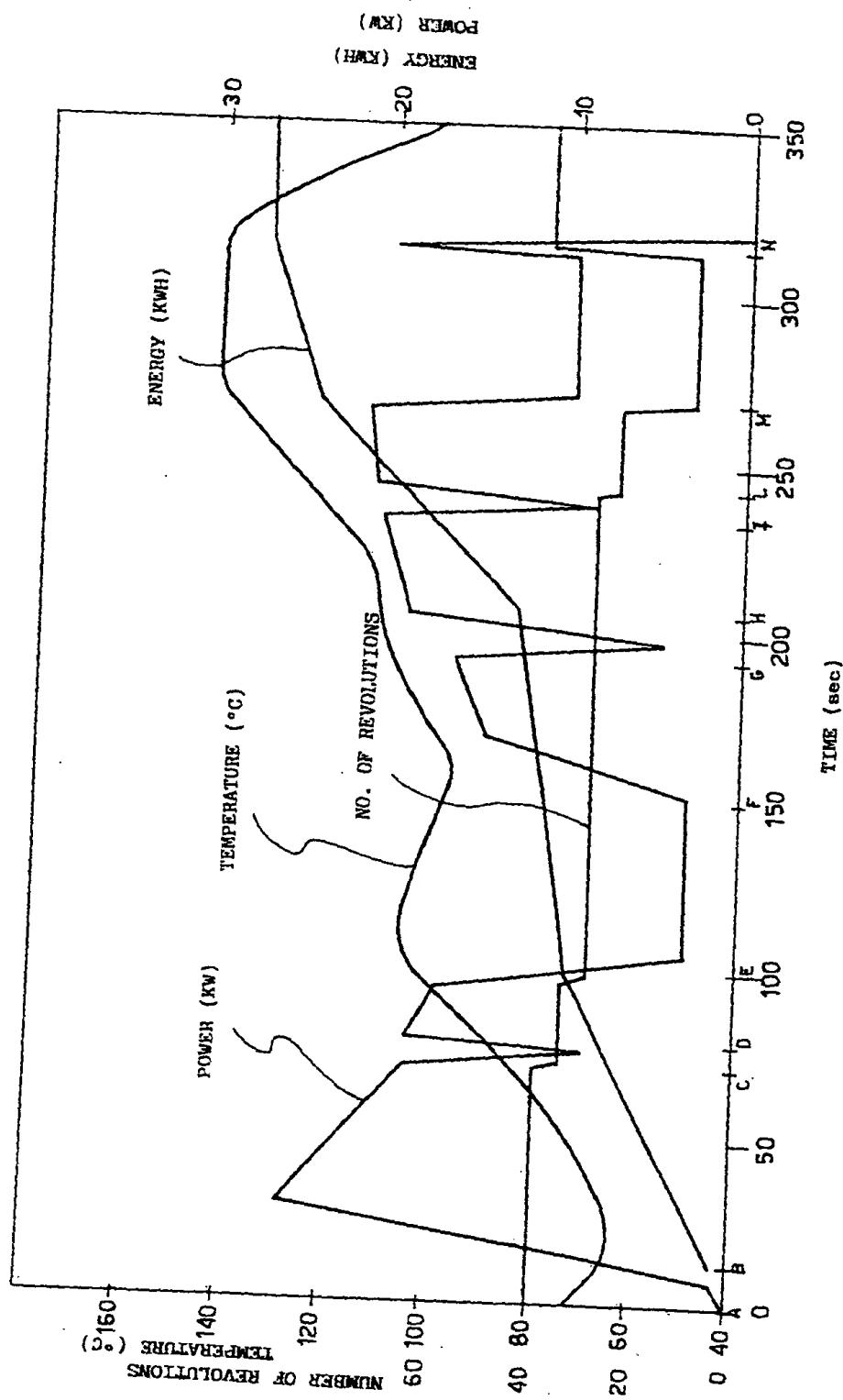


FIG. 3

| PROCESS PARAMETERS | EXPECTED PROCESS PARAMETERS AND ASSOCIATED TOLERANCES | | NON-COMPLIANT WEIGHTING | | BASIS: | | TOTAL SCORE | |
|--------------------------|---|--------|-------------------------|--------|----------|-----------|-------------|----------------------|
| | MIXTURE | | MIXTURE | | MIXTURE | | MIXTURE | |
| STEP NO. | Set value | Tol. - | Tol. + | WEIGHT | STEP NO. | Set value | Tol. - | Score |
| STEP TIME (sec) | H - 1 | 30 | 0 | 6 | H - 1 | 40 sec | NO | 6 |
| PARTIAL TEMPERATURE (°C) | H - 1 | 120 | 0 | 5 | H - 1 | 120 °C | YES | 0 |
| PARTIAL ENERGY (kWh) | H - 1 | 17.5 | 1.5 | 1.5 | H - 1 | 19.7 kWh | NO | 5 |
| STEP TIME (sec) | L - M | 25 | 5 | 6 | L - M | 42 sec | NO | 7 |
| PARTIAL TEMPERATURE (°C) | M | 145 | 0 | 0 | M | 145 °C | YES | 0 |
| PARTIAL ENERGY (kWh) | M | 24.5 | 2.4 | 2.4 | M | 27.7 kWh | NO | 8 |
| STEP TIME (sec) | M | 24.5 | 2.4 | 2.4 | N | 470 | NO | 10 |
| PARTIAL TEMPERATURE (°C) | N | 315 | 45 | 125 | N | 308 | YES | 0 |
| PARTIAL ENERGY (kWh) | N | 245 | 25 | 120 | N | 32.1 | NO | 10 |
| PARTIAL CYCLE TIME (sec) | N | 27.0 | 1.0 | 4.0 | N | 144 | YES | 0 |
| TOTAL MIXING TIME (sec) | N | 146 | 4 | 4 | | | | |
| TOTAL ENERGY (kWh) | N | | | | | | | |
| PARTIAL TEMPERATURE (°C) | N | | | | | | | |
| | | | | | | | | 45 |
| | | | | | | | | DEFECTIVE 2nd DEGREE |

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Fig. 4

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| REFERENCE CLASSIFICATION | |
|--|----------------------------------|
| PROCESS PARAMETERS | DETECTED VALUE |
| MAINTENANCE TIME OF MIXTURE INSIDE THE EXTRUDER | 11 min |
| </= 6 min | NORMAL |
| > 6 min / 9 min | DEFECTIVE 2 nd DEGREE |
| > 9 min | REJECT |

► REJECT

FIG. 5

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